

Date: Friday, 24/11/2006 7:11:30 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29688
 Estimate Number : 11028
 P.O. Number : *N/A*
 This Issue : 24/11/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 28157

Drawing Name : ARM
 Part Number : D28022
 Drawing Number : D2802 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 24/11/2006

Qty: 1 Um: Each

Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est:B 02.03.18 Re-format NG
 Est:C 06.02.13 Removed p/c EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
	Comment: Qty.: 1.5750 f(s)/Unit Total: 1.5750 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6 bar 6.00" x 0.50" Batch: <i>M/01919</i>	
		<i>J.F. 06/11/24 1</i>
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blanks 17.800" long	
		<i>J.F. 06/11/24 1</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA101 Counter sink .375 dia as per dwg	
		<i>J.F. 06/11/24 1</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
		<i>J.F. 06/11/24 1</i>
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
		<i>SD 06.11.24 1</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 24/1/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 24/11/2006 7:11:30 AM
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Drawing Name: ARM

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr NO sharp edges.

SB 06/11/27

①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

NOG/11/27

①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: WA28

RE 06.11.27

1

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/27

①

Job Completion



W 06.11.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

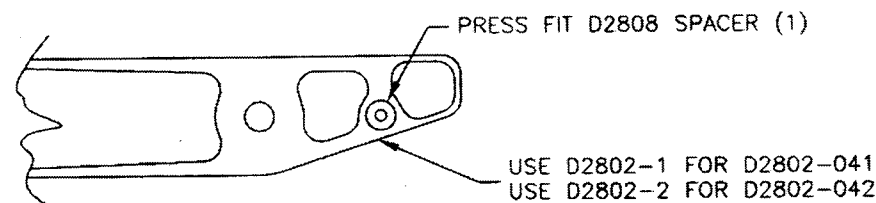
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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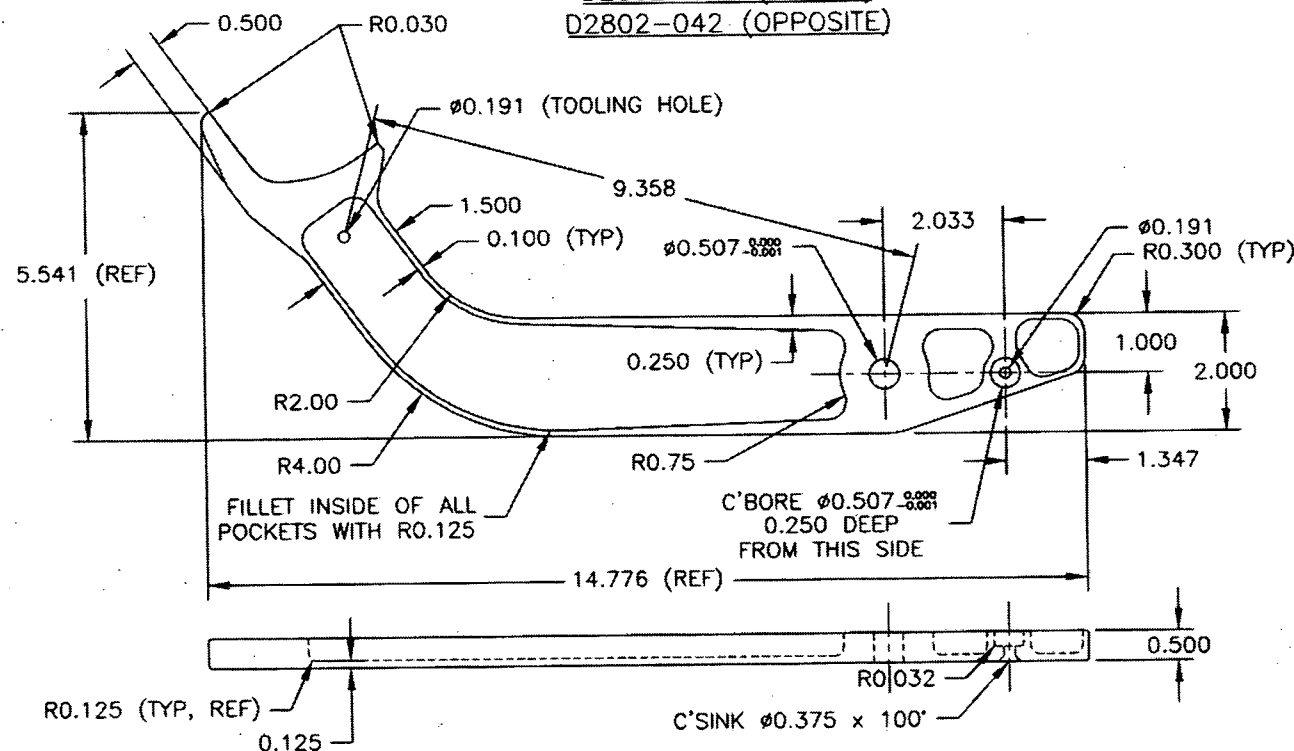
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CP</i>	APPROVED <i>CP</i>	HAMKESBURY, ONTARIO, CANADA
DATE 00.11.03	TITLE ARM	REV. A
		SHEET 1 OF 1
		SCALE 1:3
A	00.11.03	NEW ISSUE



D2802-041 (SHOWN)
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

RELEASED
00-11-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 29688
Description: Arm		Part Number: D2802-2
Inspection Dwg: D2802 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.500"	✓			
Ø0.191	+0.005/-0.001	.194"	✓			
1.500	+/-0.010	1.500"	✓			
0.100	+/-0.010	.108"	✓			
9.358	+/-0.010	9.358"	✓			
Ø0.507	+0.000/-0.001	Ø.507"	✓			
2.033	+/-0.010	2.034"	✓			
1.000	+/-0.010	1.000"	✓			
2.000	+/-0.010	2.001"	✓			
1.347	+/-0.010	1.347"	✓			
R0.75	+/-0.030	R0.75"	✓			
R0.0300	+/-0.010	R0.030	✓			
R0.125	+/-0.010	R.125"	✓			
0.500	+/-0.010	.505"	✓			
0.125	+/-0.010	.133"	✓			
Ø0.507 x 0.250	+0.000/-0.001 x +/-0.010	Ø.507x.255"	✓			
Ø0.375 x 100°	+/-0.010 x 0.5°	Ø.375x100°	✓			
0.250	+/-0.010	.250"	✓			
R0.032	+/-0.010	R.032"	✓			

Measured by: J.F.	Audited by: SA	Prototype Approval: N/A
Date: 06/11/24	Date: 06.11.24	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	